

Work Order ID 80432

80432

Page 1

February-21-12 9:13:05 AM

Item ID: D3769-5

Accept

N9000040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Tube

Start Date: 21/02/2012 Start Qty: 4.00

4

Cust Item ID:

Required Date: 06/03/2012 Req'd Qty: 4.00

4

Customer:

Reference:

Approvals: Process Plan: UL5

Date: 12/02/12

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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Draw Nbr

Revision Nbr

D3769

Rev A

100

0.00

100

Small Fab

Small Fab

Memo

0.00

Small Fab

1-cut tube to length as per dwg D37692-drill holes thru on both ends of tube as per dwg D3769 using DT9411 Jig3- deburr

8 4 FF 12-02-24

110

QC5- Inspect part completeness to step on W/O

0.00

110

QC

Memo

0.00

Quality Control

12 02 24 (4)

120

Chemical Conversion Coat per QSI005 4.1

0.00

120

HandFinish

Memo

0.00

Hand Finishing

12 2 27 (4)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 80432

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February-21-12 9:13:05 AM

Item ID: D3769-5 Accept *N9000040100* Setup Start *NS1*
 Revision ID: Stop *NS2*
 Item Name: Tube
 Start Date: 21/02/2012 Start Qty: 4.00 *4* Cust Item ID:
 Required Date: 06/03/2012 Req'd Qty: 4.00 *4* Customer:
 Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start *NR1*
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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130	QC3- Inspect Part Finish	0.00							
130									
QC	Memo	0.00				01/2/29		(4)	J
Quality Control									

140	Identify as per dwg & Stock Location <u>251A</u>	0.00							
140									
Packaging	Memo	0.00				12/2/29		(4)	J
Packaging									

150	QC21- Final Inspection - Work Order Release	0.00							
150									
QC	Memo	0.00							
Quality Control									

mf 12-02-29

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Picklist Print

February-21-12 9:13:08 AM

Page 1

Work Order ID: 80432

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Parent Item: D3769-5

D3769-5

Parent Item Name: Tube

Start Date: 21/02/2012

Required Date: 06/03/2012

Start Qty: 4.00

Required Qty: 4.00

Comments: IPP Rev:A 08-06-18 rev.A as per dwg DD verified by:EC
IPP Rev:B 08-08-27 Drilling Tooling Added JLM Verified By:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6T1.000W065		Purchased	No			100	f	95.3728	1.6742	7.049263			

M6061T6T1 000W065

6061T6 RD TUBE 1.00 x .065w

**

④ FF 12-02-23

Location

Loc Qty

Loc Code

MAT015

95.3728

114089

0.3114

116720

2

117983

93.0614

7.0492

W/O:		WORK ORDER CHANGES					
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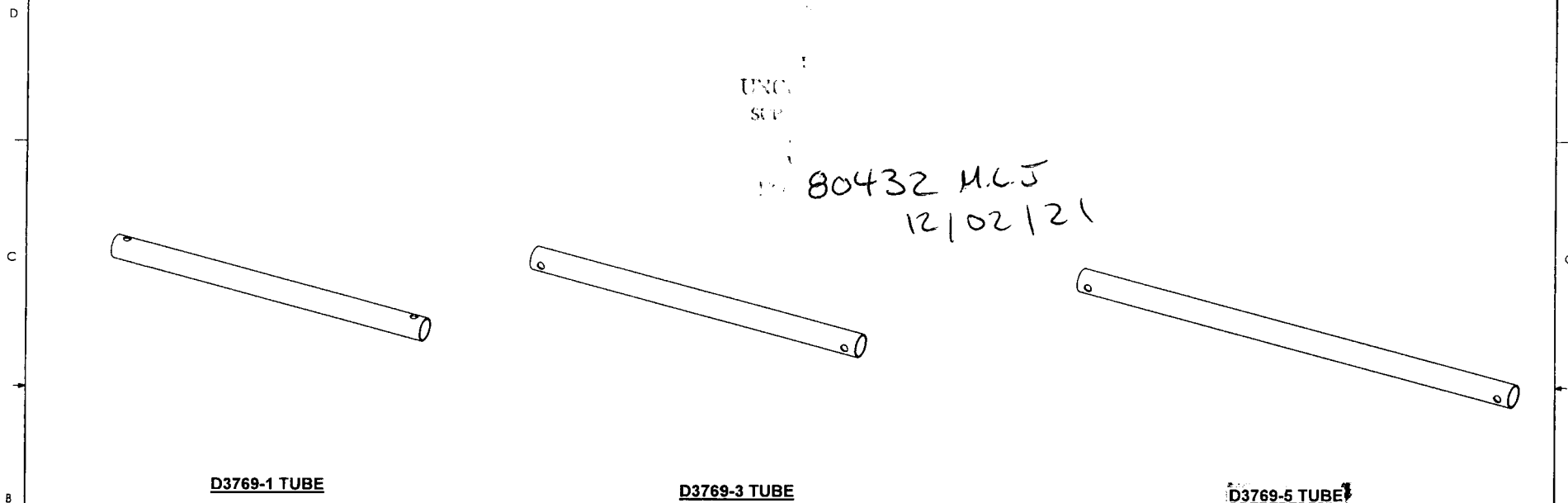
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8 7 6 5 4 3 2 1



D3769-1 TUBE

D3769-3 TUBE

D3769-5 TUBE

RELEASED
08-06-17-14

NOTES:

- 1) MATERIAL: 6061-T6 OR 6061-T62 ALUMINUM TUBING (1.00" X 0.065" WALL) PER WW-T-700/6 OR AMS 4080 OR AMS 4082 OR QQ-A-200/8 OR QQ-A-225/8 (REF. DART SPEC. M6061T6T1.000W.065)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: D3769-1, 0.27 lbs
D3769-3, 0.28 lbs
D3769-5, 0.37 lbs

A NEW ISSUE		HS	08.06.04
REV.	DESCRIPTION		BY DATE
DESIGN	HS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
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MFG. APPR.	<i>[Signature]</i>	D3769	SHEET 1 OF 4
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8 7 6 5 4 3 2 1

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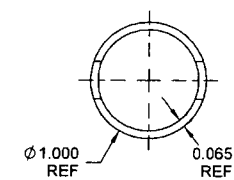
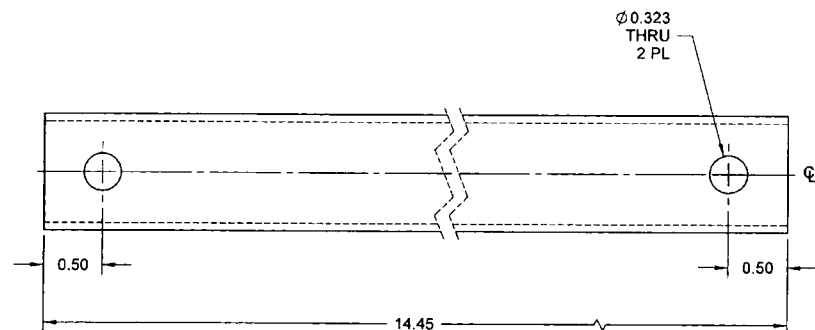
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D3769-1 TUBE

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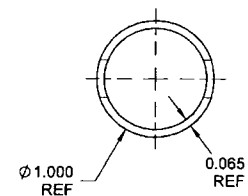
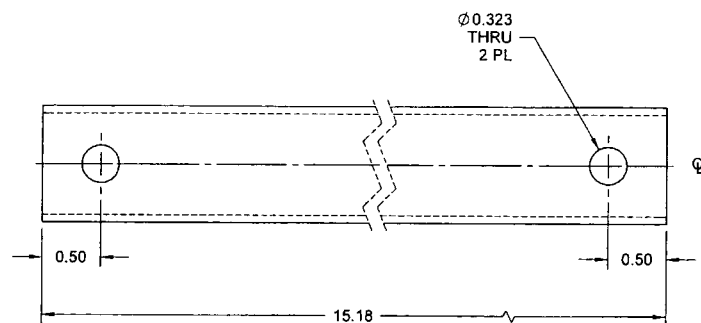
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D3769-3 TUBE

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08-06-14/10

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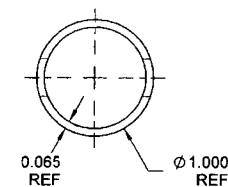
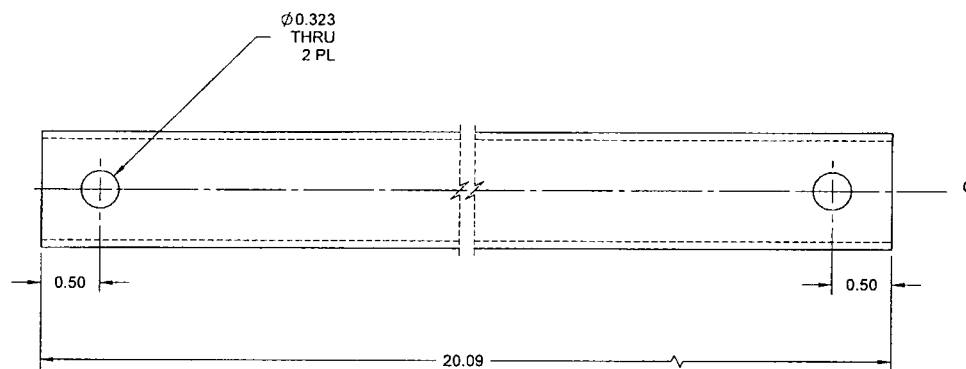
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D3769-5 TUBERELEASED
08-06-16

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